

Work Order ID 53703

November 12, 2009 3:04:03 PM

Page 1

Item ID: D3719-041

Revision ID: A

Item Name: Wearplate

Start Date: 11/12/09 Start Qty: 8.00

Required Date: 11/20/09 Req'd Qty: 8.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3719 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 9-11-12

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-11-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

14

10-11-13

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Item ID: D3719-041

Accept



Setup Start



Revision ID: A

Item Name: Wearplate

Stop



Start Date: 11/12/09 Start Qty: 8.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3719 2-Weld hard facing as per Dwg D3719 A/R 2059B Hard Coat rod Batch: <u>M112 963</u>								
140		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

SP/12 09.11.17.

CPC 09.11.18

(114) /

278 02/11/18

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Item ID: D3719-041

Accept

Revision ID: A

Item Name: Wearplate

Start Date: 11/12/09 Start Qty: 8.00

Required Date: 11/20/09 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:15 AM

OVEN TEMPERATURE:

9:45 AM FINISH TIME:

320°C

⇒ Jd 09/11/19 (X14) Ø

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 09-11-19

(14)

180

Identify as per dwg & Stock Location: 501

0.00



Packaging

Memo

0.00

Packaging

9/11/19 R4x SP

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Item ID: D3719-041

Accept

Revision ID: A

Item Name: Wearplate

Start Date: 11/12/09 Start Qty: 8.00

Required Date: 11/20/09 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26 *[Signature]**PK 09-11-20*

Picklist Print

November 12, 2009 3:04:02 PM

Page 1

Work Order ID: 53703

Parent Item: D3719-041RevA

Parent Item Name: Wearplate


Comments:

Start Date: 11/12/09

Required Date: 11/20/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3009-3RevB  Cup		Manufactured	No			100	Each	561.0000	32.0000			

EL 9-11-17

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

561

42376

158

42377

403

56

M304S16GA

Purchased

No

130

sf

199.1742

4.7579

8.5

11-11-12

304/316 Sheet .063

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

199.1741737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

127.8

112885

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

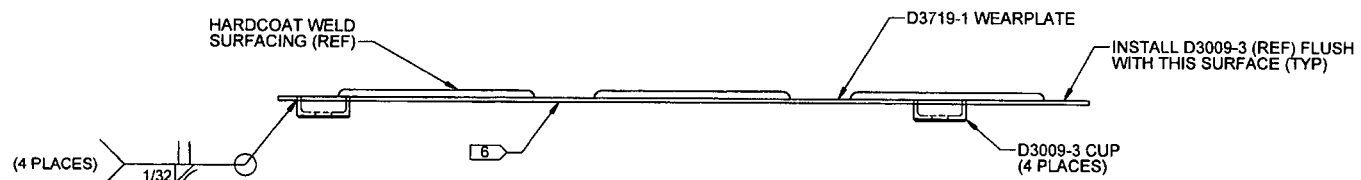
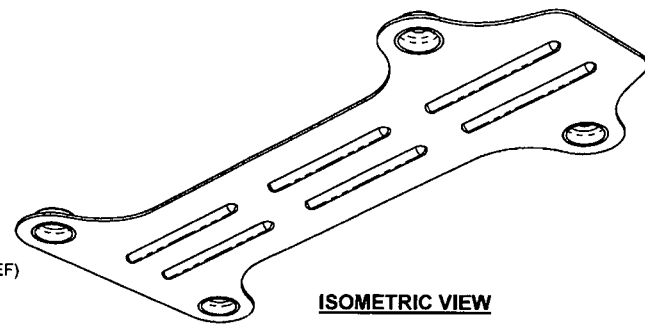
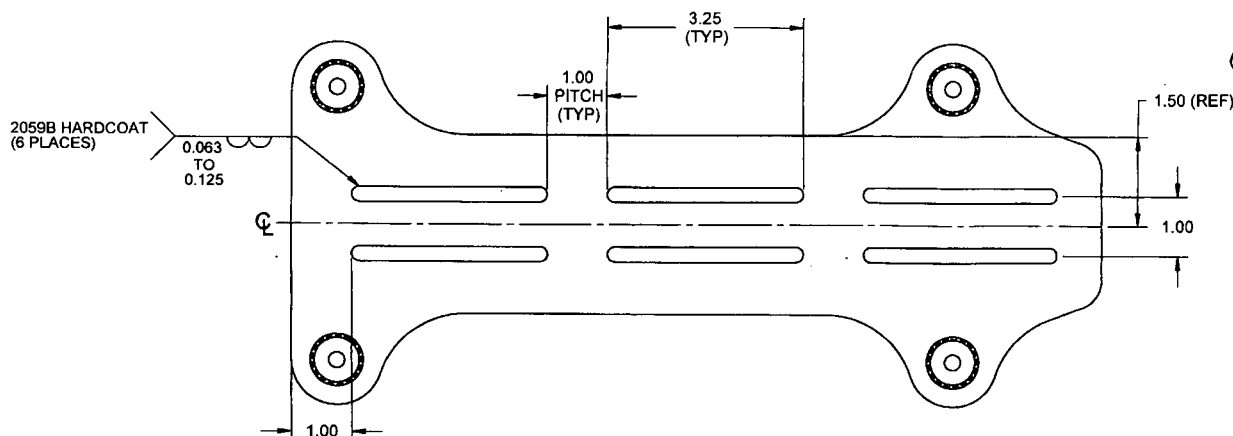
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP

WLO 53703



D3719-041 WEARPLATE

RELEASED
07-01-07

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

NEW ISSUE		CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3719** REV. A
SHEET 1 OF 2

TITLE **WEARPLATE** SCALE 1:2

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